Work Order ID 106415 August-29-13 1:39:44 PM				Page 1							
Item ID: Revision ID: Item Name:	D3200-1 Door Post Block		. <u></u>	Accept	*N900	04010) () *	Setup Start	ı VI.	S1* S2*	=
Start Date: Required Date: Reference:		ty: 20.00 Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					
Approvals:	Process Plan:	ري کي	Date: 13 - 08 - 30 Tooling:		D	ate:		Run Start	"INKI"		
	QC:				· D	ate:	. <u></u>	Stop	*N	R2*	
Sequence ID/ Work Center II	Operati D Descrip			Set Up/ Run Hours	Tool ID	Tool # Plan	-	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nb	r								_ 	
D3200	Rev A						•	,			
100				0.00	MH 13/4	19/06	77	8		······································	
100 Bandsaw Jeaspa Bandsaw	BAND S.	Memo	.700" x 2.700	0.00		·				—- 	
¹¹⁰ *11∩ *	HAAS C	NC VERTICAL	. MACHINING #1	0.00	DR/H.a		_ <u>2</u> 2	1			
HAAS J		Memo		0.00	13/09/07		00	<u> </u>			
HAAS CNC vertica	l machine #1	1-Machine I	03200-1 as per Folio FA3	37 and Dwg D32002-Del	burr						
120	QC2- Ins	pect parts off m	achine FAI/FAIB	0.00	TC/ b.A 13/09/67		_	_			
12∩ ∞		Memo		0.00	13/09/07		22	. <i>P</i>			

Quality Control

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
	•									QA Closed:	Date	· -		
Work Orde	r:				DISPOSITION	_	AGAINST DEPARTMENT/PROCESS							
Part N	Part No.			Rework Scrap Use-as-is Work Order Update	Thermoforming Finishing			Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
INCK IN	o	-			Work Order Opdate	<u> </u>		Laige rab			Juppiici			
Root					ption of work order update		nitial	Ì	tion	Sign &	_			
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling		1				Ì								
Operator														
Material			<u> </u>											
Setup]]									1		
Other	_			•										
Process						1								
Supplier	_													
Training	4		1											
Unapproved		<u> </u>	<u>L</u>				T CATE	CORY	<u> </u>	l				
Landin	ng Gear				General	FAUL	T CATE	GURT			<u> </u>			
Landin	Bending			Г	Bend		Grain			Ovalized		Pressure/Forced		
ŀ	Centre N	ot Concei	ntric to ()/s	BOM/Route	\vdash	Hardwa	ire	 	Over/Under	tolerance	Temperature/Cure		
}	Cracks	or conce		""	Broken/Damaged	-		ion Incomplete		Part Incorre		Weld		
<u> </u>	Crushed/	Crimped		ļ	Burrs	-	-	ions incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
İ	Cuffs	O			Contamination	-	Mainte	•		Part Moved	· _	_ ·		
ł	Heat Trea	at			Countersink	H	Mislabe	eled	-	Positioned V	Vrong			
Ì	Inspectio		Tube		Cut Too Short	П	Misread	d		Power Loss/	Surge	Other		
ļ	Ripples in		-		Drill Holes	-	Offset		<u> </u>	-				
ļ	Torque V		Extrusion	,	Drawing	\Box	Out of 0	Calibration						
	Turning S				Finish		Out of S	Sequence				_		

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
						·					QA Closed:	D.	ate:	
Work Ord	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Order: Part No. NCR No.			Scrap Machining Sm Use-as-is Thermoforming Fi		Machining Small Fab noforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other				
Root					Descri	ption of work order update		Initial	Action		Sign &	-		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	on	QC Inspector
Doc/Data								·						ļ
Equip/Tooling]			•				İ				
Operator					İ				1			•		
Material														
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Other				1										
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Supplier					1		ł							
Training			1											
Unapproved			<u> </u>	<u> </u>										<u> </u>
				_		F.	AUL	LT CATE	GORY					
Landi		• -			_	General		,	٠ _		1		_	1
		Bending		•	<u> </u>	Bend		Grain		_	Ovalized		<u> </u>	Pressure/Forced
	匚	Centre N	ot Conce	ntric to	O/S	BOM/Route		Hardwa	· ·	_	Over/Under t		<u> </u>	Temperature/Cure
		Cracks				Broken/Damaged	<u></u>	Inspection Incomplete		_	Part Incorrect			Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear	_	Part Lost/Mis	sing	_	Wrong Stock Pulled
	$ldsymbol{le}}}}}}}$	Cuffs			ļ	Contamination		Mainte	⊢	-	Part Moved			
	$ldsymbol{ld}}}}}}$	Heat Trea			<u> </u>	Countersink	<u></u>	Mislabe	<u>+</u>	_	Positioned W	_		1
	L	Inspectio		Tube	<u> </u>	Cut Too Short	_	Misread	· [Power Loss/S	urge		Other
	\sqsubseteq	Ripples in	n Bend		<u> </u>	Drill Holes		Offset						
		Torque V	Vaves in E	Extrusio	n	Drawing		Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

August-29-13 1:39:44 PM

Work Order ID:

106415

Parent Item:

D3200-1

Parent Item Name:

Door Post Block

Start Date: 8/29/13

Required Date: 8/29/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black	·	Purchased	No			100	sf -	607.0003	0.05	1.052632			·
				Location		Loc Qtv	<u>Lo</u>	c Code					
				MAT019		607.0002895					- 41 1	0/04/	o.c
				- 1212	278	11.0002895			1.0	2 re 3r	MH	أدماه	
				1225	575	47.6							•
				1232	229	53							
				1237	704	63.8							
				1239	949	6.96							
				1243	382	197.12							
				1247	758	17.52							
				1251	137	210							

Page 1

											DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	VFORM	ANCE / UP	DATE			_	
				<u> </u>						· · · · · · · · · · · · · · · · · · ·	QA Closed:	Da	te:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Work Order: Part No. NCR No.			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other			
				, ,				L		-	- 		_	
Root	- [otion of work order update		Initial	Act		Sign &		[
Cause	.	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verificatio	n	QC Inspector
Doc/Data	Ш		}				1							
Equip/Tooling	Ш													
Operator	Щ													
Material	\vdash		ļ											
Setup	Н										İ			
Other	Н							;						
Process	dash								10		}			
Supplier	Н						}							
Training	\vdash													
Unapproved	<u>l. </u>		1	Ll		F	AUL	T CATE	GORY		<u> </u>	L		
Landi	ng G	 Gear	_			General		···						
	_	Bending				Bend		Grain			Ovalized			Pressure/Forced
	П	Centre No	ot Concei	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
	П	Cracks		Broken/Damaged			Inspecti	on Incomplete		Part Incorre	ct		Weld	
	П	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing		Wrong Stock Pulled
	П	Cuffs				Contamination		Mainte	nance		Part Moved			
		Heat Trea	ət			Countersink		Mislabe	led		Positioned V	Vrong		
	П	Inspectio	n Strip in	Tube		Cut Too Short		Misread				Surge		Other
		Ripples in	Bend			Drill Holes		Offset		_				
		Torque W	Vaves in E	Extrusion	n [Drawing		Out of 0	Calibration			· · · · · · · · · · · · · · · · · · ·		

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

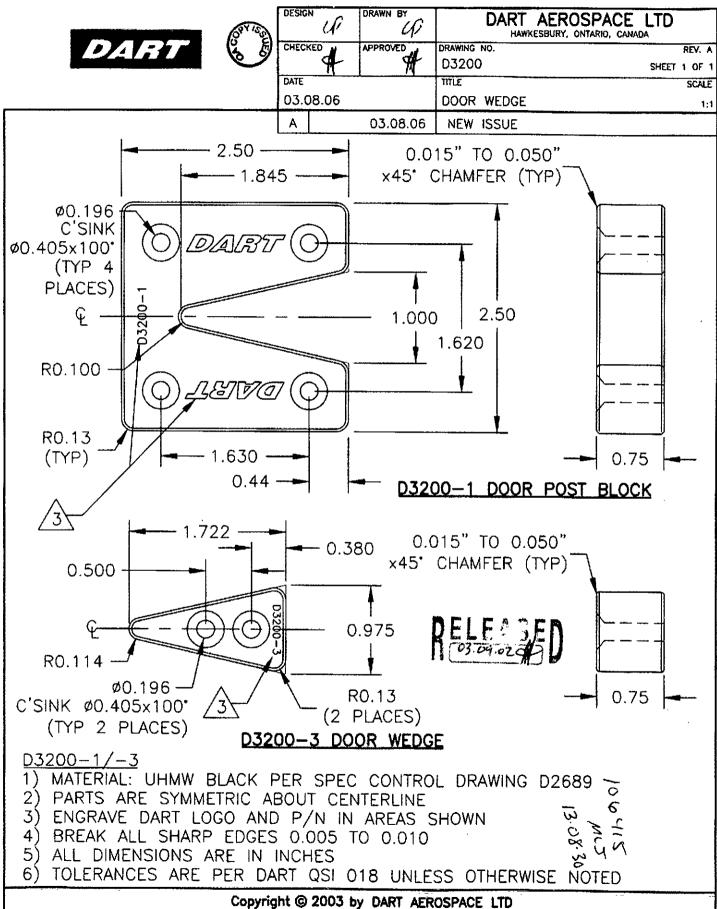
Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	106415
Description: Door Post Block	Part Number:	D3200-1
Inspection Dwg: D3200 Rev: A		Page 1 of 1

nspection Dwg	. D3200	Rev: A					'age 1 of 1
	F	IRST ARTICLE	INSPEC	TION CH	IECKLIST		
		X First A	rticle	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
Ø0.196	+0.005 -0.000	,196	i/		A.N.	DAUGE	,
0.405 x 100°	+/-0.010	.416	/		DROS	6"	en
R0.100	+/-0.010	R. 100			RADIL		
R0.130	+/-0.010	R. 130	1		KHISIC	بی دا	1-0-6
1.630	+/-0.005	1.628	V		DROS	6"ULEN	 ن،
0.440	+/-0.030	.435	1	,	DROS	6'VER	
2.500	+/-0.010	2.459	/		DROS	6"001	2N.
1.845	+/-0.010	1.845	V		HIEGHT	GHUL	
0.015 — 0.050	N/A	.045			DEOS	6"Hex	
1.000	+/-0.010	1.00 6	/		DROS	6 VER	
1.620	+/-0.005	1.619	7	-	DROG	6"VEX	
2.500	+/-0.030	2.499	V		DE 05	6"ver	
0.750	+/-0.030	.748	/		DP 05	6 West	
••••							
				<u>_</u> _			
							<u> </u>
1.		7	- OAS	·			
leasured by:	2/A-	Audited by:	- 2-83		Prototype App		N/A
Date: /	3/09/07	Date:	13/09/0	4	<u> </u>	Date:	N/A
Rev Date	Change				R	evised, by	Approve
A 03.11.12	New Issue	P/O D412-	698-015			J/RF مر	

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